

Date: Tuesday, 7/25/2006 7:48:25 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PLATE
Job Number	: 28027		
Estimate Number	: 10425		
P.O. Number	: <i>NIA</i>	Part Number	: D32191
This Issue	: 7/25/2006	S.O. No.	: <i>NIA</i>
Prsht Rev.	: NC	Drawing Number	: D3219 REV A
First Issue	: <i>NIA</i>	Project Number	: N/A
Previous Run	: 27865	Drawing Revision	: A
	Type : MACHINED PARTS	Material	: <i>NIA</i>
Written By	<i>SEE COMMENT BELOW</i>	Due Date	: 8/1/2006
Checked & Approved By	: <i>06.07.25</i>	Qty:	60 Um: Each
Comment	: Est. A0404.19 New issue KJ/JLM ESR B 06.05.25 Waterjet EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S125	6061-T6 .125 Sheet
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Comment: Qty.: 0.1012 sf(s)/Unit Total : 6.0732 sf(s)
 6061-T6 .125 Sheet
 To be made in multiples of 4
 Material: 6061-T6 (QQ-A-200/11) 0.125" thick
 (M6061T6S.125) Batch: *m101092*

ml 06 07 25

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3219
 Dwg Rev: *A*
 Prog Rev: *A*

2-Deburr if necessary

*ml 06 07 25**(60)*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*ml 06 07 25**(60)*

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*ml 06 07 25**(60)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: SP Date: 06/08/01

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if necessary.

FF 06.07.26 60

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-07-26 (59) PTO

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA 9

06-07-26 59

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21


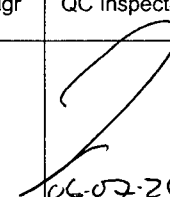
06/08/01

Job Completion



06/08/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06-07-26	6-D	1 part scrap. blow out from water jet close to the top hole.		destroyed.	J.E. 06-07-26	 06-07-26		 06-07-26

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

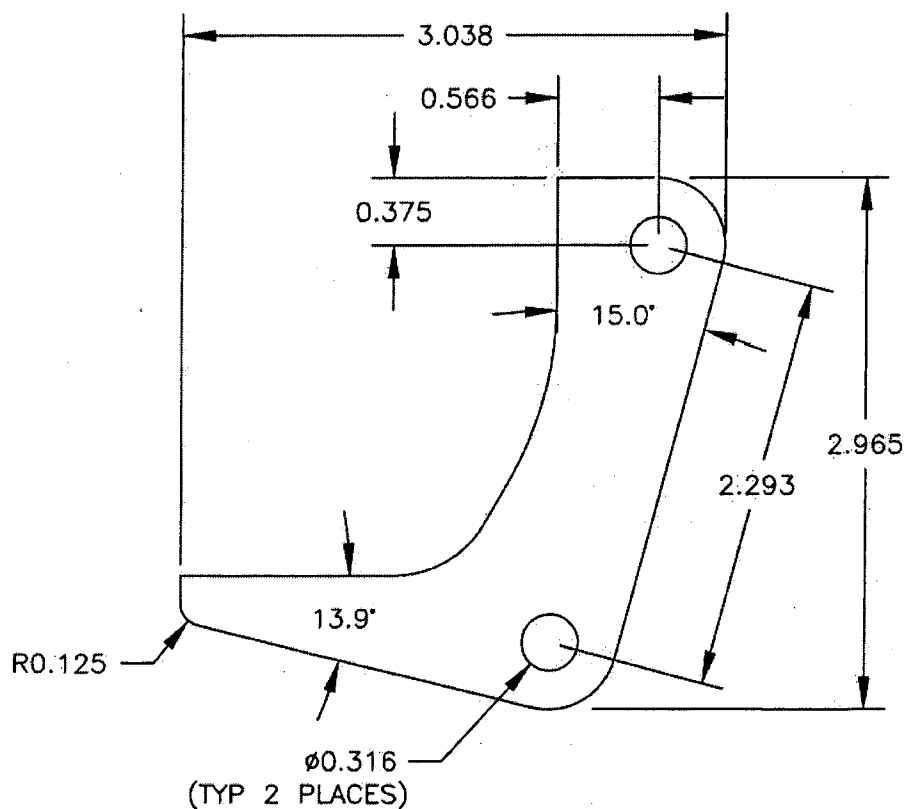
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3219	REV. A SHEET 1 OF 1
DATE 03.10.10		TITLE PLATE	SCALE 1:1
A	03.10.10	NEW ISSUE	

RELEASED
04.04.05



D3219-1 PLATE

- 1) MACHINE PER DWG FILE "D3219-1.SLDPRT"
- 2) MATERIAL: 6061-T6, 0.125 THICK (QQ-A-250/11)
(REF DART SPEC M6061T6S.125)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
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WORK ORDER
NO. 28027

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